

20-8313



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.3911

Job Sheet 203837



Part No: 647.3911

Job Qty: 12 pcs

11 DAS
21
9-89

Part Name: 212 Upper Deflector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/19

Job Tracking No:

Due Date: 1/12/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV C2 SHEETS 1,4,5 IPP REV. A NEW ISSUE JFS 14/05/21 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs		1/12/20	0.00	0.60	Bandsaw - 1	52 DAS-89 9-89	20/04/02
110	HAAS 5 Axis - B4B	12 pcs		1/12/20	0.75	10.14	HAAS - 5 - B4B	52 DAS-89 9-89	20/04/02
120	QC 2	12 pcs		1/12/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S268314



Part: 647.3911

Job No: 203837

Serial No/Batch: S268314

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/02/20

Plex 11/28/19 8:30 AM Dart.Renwick.Jennifer

					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	12	1/12/20	0.00 0.00	QC 8 - 12	
	pcs				QC 8 - 14	On 26/04/02
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140	Outsource - 4 - Anodize	12	1/12/20	0.00 0.00	ATG 001	KE 2020-04-07
	pcs				Packaging 2 - 1 - B4B	
150	Packaging 2-1 - Receive - B4B	12	1/12/20	0.00 0.00	Packaging 2 - 2 - B4B	
	pcs				Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	KE APR 7 8 2020
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 -	

						B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
155 QC 5 46	12 pcs	1/12/20	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
						180 Packaging 3-1 - Stock - B4B	12 pcs
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Plex 11/28/19 8:30 AM Dart.Renwick.Jennife	

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Part Op **100** - (Bandsaw) Cut Blank at 34.125" *** ONE BLANK MAKES TWO PARTS***
 Descriptions: **110** - HAAS1-5 (HAAS CNC Vertical Machine) 1-Machine per folio FB299 DWG REV: C FOLIO
 REV: 44 2- deburr and break all sharp edges
120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 46239 1- Black Anodize as per Dwg 647.3900 2- PRIME AS PER DWG, SEE NOTE #9 Certification of Conformity is required
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 155 - (QC5- Inspect part completeness to step on W/O)
 180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S0.375X6.000	7075-T6S Sheet .375" Thick Plate X 6" Wide	17.0640 ft (1.422 ea)	100-Bandsaw - 1	<u>5255554</u> <u>5246093</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S0.375X6.000	17	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	212 Upper Deflector	0.125inches $\pm$ 0.005	0.130 0.120	<u>.130</u>	
2	212 Upper Deflector	44.900degrees $\pm$ 0.500	45.400 44.400	<u>45</u>	
3	212 Upper Deflector	0.177inches $\pm$ 0.005 - 0.001	0.182 0.176	<u>.177</u>	diameter
4	212 Upper Deflector	2.110inches $\pm$ 0.002	2.112 2.108	<u>2.111</u>	
5	212 Upper Deflector	4.220inches $\pm$ 0.002	4.222 4.218	<u>4.221</u>	
6	212 Upper Deflector	0.700inches $\pm$ 0.005	0.705 0.695	<u>.702</u>	
7	212 Upper Deflector	0.340inches $\pm$ 0.000 - 0.002	0.340 0.338	<u>.340</u>	
8	212 Upper Deflector	0.035inches $\pm$ 0.005	0.040 0.030	<u>.040</u>	
9	212 Upper Deflector	45.000degrees $\pm$ 0.500	45.500 44.500	<u>45</u>	angle
10	212 Upper Deflector	0.375inches $\pm$ 0.005	0.380 0.370	<u>.375</u>	
11	212 Upper Deflector	15.896inches $\pm$ 0.005	15.901 15.891	<u>15.896</u>	
12	212 Upper Deflector	0.312inches $\pm$ 0.005	0.317 0.307	<u>.311</u>	
13	212 Upper Deflector	6.446inches $\pm$ 0.005	6.451 6.441	<u>6.446</u>	
14	212 Upper Deflector	15.046inches $\pm$ 0.005	15.051 15.041	<u>15.046</u>	
15	212 Upper Deflector	0.189inches $\pm$ 0.005 - 0.001	0.194 0.188	<u>.191</u>	diameter
16	212 Upper Deflector	35.800degrees $\pm$ 0.500	36.300 35.300	<u>35.8</u>	angle
17	212 Upper Deflector	40.200degrees $\pm$ 0.500	40.700 39.700	<u>40.2</u>	angle

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Tel (613) 632-5200

PURCHASE ORDER **POHB046239**



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046239

PO Date: 4/7/20

Due Date: 4/22/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-04-13

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200855	646.9715	646.9700 Rev H	Body : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1), Issue P/O to: Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed - X4		4/13/20	4 pcs	0 pcs	4 pcs	\$16.86/pcs	\$67.44 APR 14 2020
2	208851	647.1515	647.1500 Rev E	Upper Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed - X4		4/13/20	4 pcs	0 pcs	4 pcs	\$14.41/pcs	\$57.64 APR 14 2020



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PURCHASE ORDER

POHB046239



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	208610	649.4811	649.4800 Rev E	Clip : Various STC's Issue P/O: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X4	-	4/13/20	4 pcs	0 pcs APR 14 2020	4 pcs	\$11.96/pcs	\$47.84
4	204803	646.3010	646.3000 Rev NC1	LH Half : Various STC's Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3000	Firmed X30	-	4/22/20	30 pcs	0 pcs APR 28 2020	30 pcs	\$12.61/pcs	\$378.30



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PURCHASE ORDER

POHB046239



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	203837	647.3911	647.3900 Rev C2	212 Upper Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 1- Black Anodize as per Dwg 647.3900 2- PRIME AS PER DWG, SEE NOTE #9 Certification of Conformity is required	Firmed (X1)	-	4/22/20	11 pcs	0 pcs	11 pcs	\$26.86/pcs	\$295.46
											Grand Total:	
											\$846.68	

APR 28 2020

DAS
81
9-89

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A046 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/13/20 10:17 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Number: 920019

Date: 21-Apr-20

Pack List

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
30 ea	Part: 646.3010 LH Half Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (6 - .9 mils) per drawing. Batch/Lot#: 5236137 Job: 27304 PO: POHB046239	Rev: NC Expiry Date: 05/29/2021 Line: 4	
11 ea	Part: 647.3911 212 Upper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (1.2 mils) per drawing Batch/Lot#: 5236137 Job: 27305 PO: POHB046239	Rev: C2 Expiry Date: 05/29/2021 Line: 5	DAS 81 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: APR 21 2020 Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920019

Date: 21-Apr-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.		

Aug 18 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8513

Route update only

Job: <u>203837</u>		DISPOSITION		DEPARTMENT/PROCESS							
Part No. <u>647.3911</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>20-8-6</u>		Sequence #: <u>110</u>		QTY Affected: <u>1</u>				MRB (QSI042)			
Description Work Order Deviation				Disposition				DAS 9 9-89 <u>20-8-6</u>			
<u>.340 - .002 measurement is out of tolerance</u>				<u>Scrap, no replace</u>				Completed By <u>DAS</u> <u>65</u> 9-89 <u>20/04/02</u>			
								Lead hand / Supervisor <u>mx</u> <u>20/04/02</u>			
								QC / QA Coordinator <u>DAS</u> 9 9-89 <u>20-8-6</u>			
Root Cause		FAULT CATEGORY									
Operator ☒		☐ Pressure/Forced		☐ Contamination		☐ Power Loss/Surge		☐ Positioned Wrong			
Manufacturing Process ☐		☐ Bending		☐ Misaligned/off center		☐ Folio/Program		☒ Outside Tolerance			
Equip/Tooling ☐		☐ Crushing		☐ BOM/Route		☐ Grain Direction		☐ Drawing			
Handling/Preservation ☐		☐ Cracks		☐ Broken/Damage/Defect		☐ Weld		☐ Finish			
Material ☐		☐ Crimp/Kink/Ripple/Wave/Twist		☐ Incomplete/Unclear Instructions		☐ Wrong Stock Pulled		☐ Part Lost/Missing			
Product Improvement ☐		☐ Marks/Chatter		☐ Drill Holes		☐ Out of Sequence		☐ Misread			
Process Improvement ☐		☐ Mislabeled		☐ Fit/Function		☐ Off-set/Set-up					
Human Factors ☐		Other/Details:									